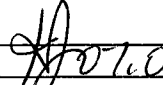
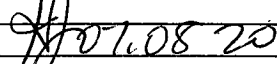


Date: Friday, 17/08/2007 11:21:14 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLOWER MOTOR SUPPORT
Job Number	: 34083		
Estimate Number	: 12309		
P.O. Number	: N/A	Part Number	: D3471043
This Issue	: 17/08/2007 S.O. No. : N/A	Drawing Number	: D3471 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 28559	Material	: N/A
Written By	: 	Due Date	: 11/09/2007
Checked & Approved By	: 	Qty:	8 Um: Each
Comment	: est rev A 06.03.02 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MS3584216	CLAMP
-----	-----------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
pick:

Qty	Part number	Description	Batch
1	MS35842-16	CLAMP	M105408x5 / m 100761x3 FF 07-09-06

2.0	MS20427M44	RIVET
-----	------------	-------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 24.0000 Each(s)
pick:

Qty	Part number	Description	Batch
3	MS20427M4-4	Rivet	M100393x18 / M105408x5 FF 07-09-06

3.0	D34713	SUPPORT
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
pick:

Qty	Part number	Description	Batch
1	D3471-3	Support	B94103x7 B26126x1

FF 07-09-06

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3471

FF 07-09-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/09/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/06	4	3 clamp shifted when Transferring Hole. Hole off centre. Hole is oval as well. R.C. Transfer drilling from Aluminum to steel, causing the drill bit to wander. - tell employee to use Tant Transfer Punch.	<i>QSIWZ</i>	Set up and reworked (07/09/06) 11/10/06 (39) Replace 3X0 3471-3 B 26126x1 B 334103 x2	07/09/06 FF	<i>En</i> 07/09/10	<i>QSIWZ</i>	<i>10709-06</i>

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:21:14 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 34083

Part Number: D3471043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 07/08/10 (8)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

FF 07-09-10

8

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(8)
R 07/08/11

Job Completion



U 07-09-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

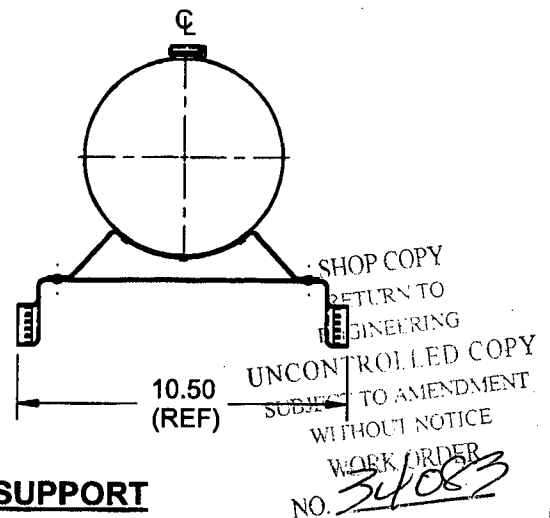
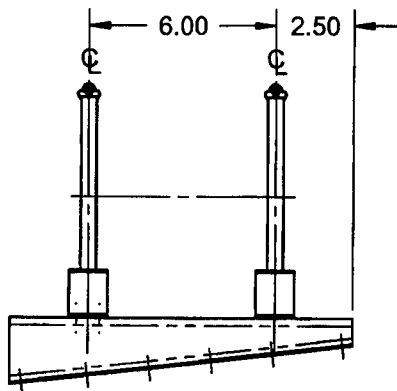
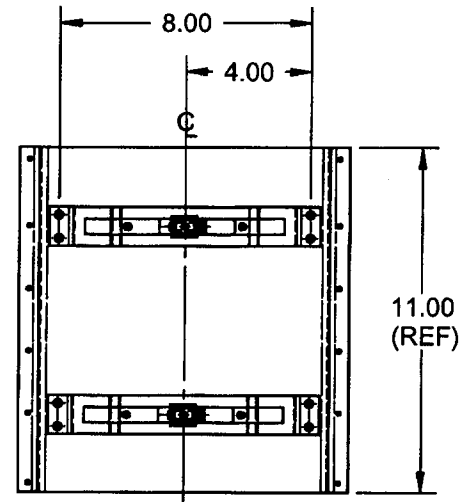
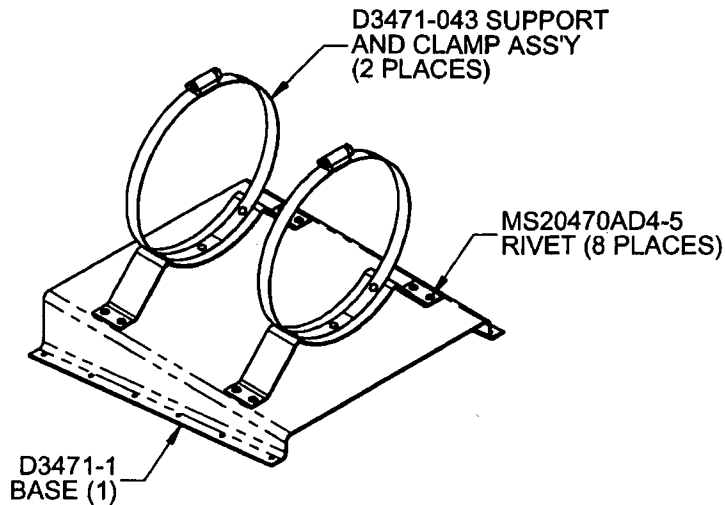
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3471	REV. A SHEET 1 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:6
A	05.12.21	NEW ISSUE	

**D3471-041 BLOWER MOTOR SUPPORT****NOTES:**

- 1) IDENTIFY WITH DART P/N D3471-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3471-041	BLOWER MOTOR SUPPORT
2	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-1	BASE
8	MS20470AD4-5	RIVET

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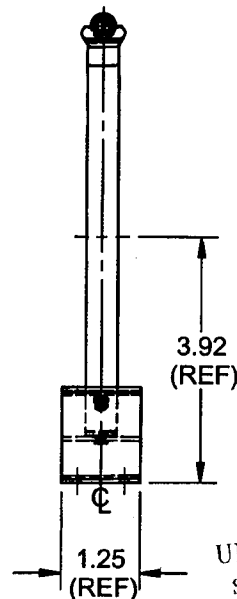
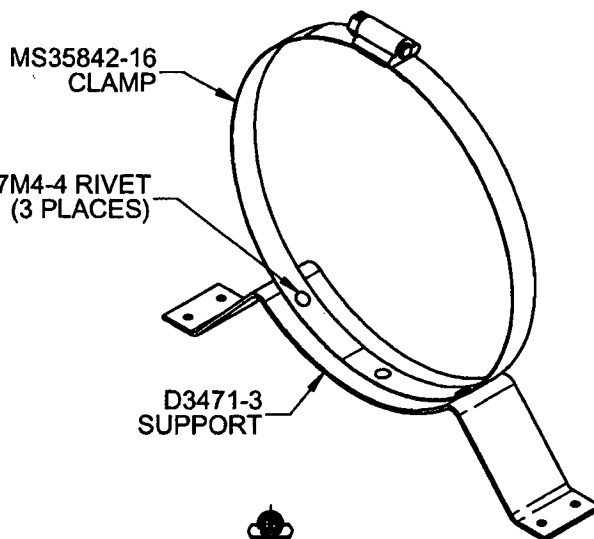
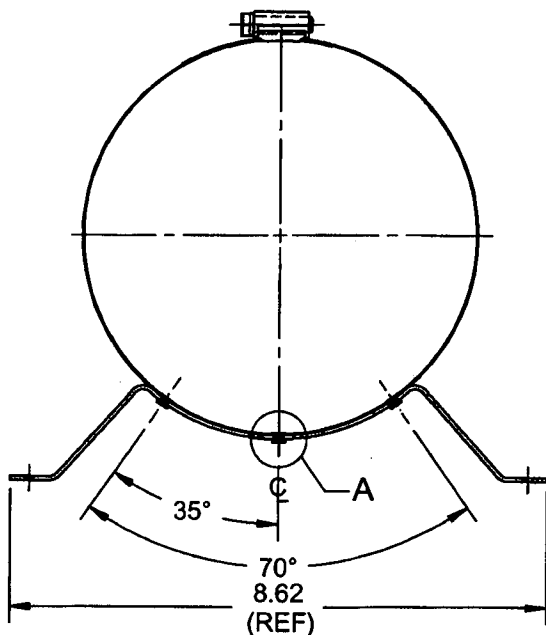
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3471	REV. A SHEET 2 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT SCALE 1:3	

06.04.03 *[Signature]*

LOCATE AND TRANSFER DRILL
#30 ($\phi 0.129$) THRU HOLE FROM
D3471-3 TO MS35842-16 CLAMP
AND C'SINK $\phi 0.230 \times 100^\circ$
(3 PLACES)



DETAIL A: COUNTERSINK HOLES
(RIVET NOT SHOWN FOR CLARITY)
SCALE 1:1



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D3471-043 SUPPORT & CLAMP ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

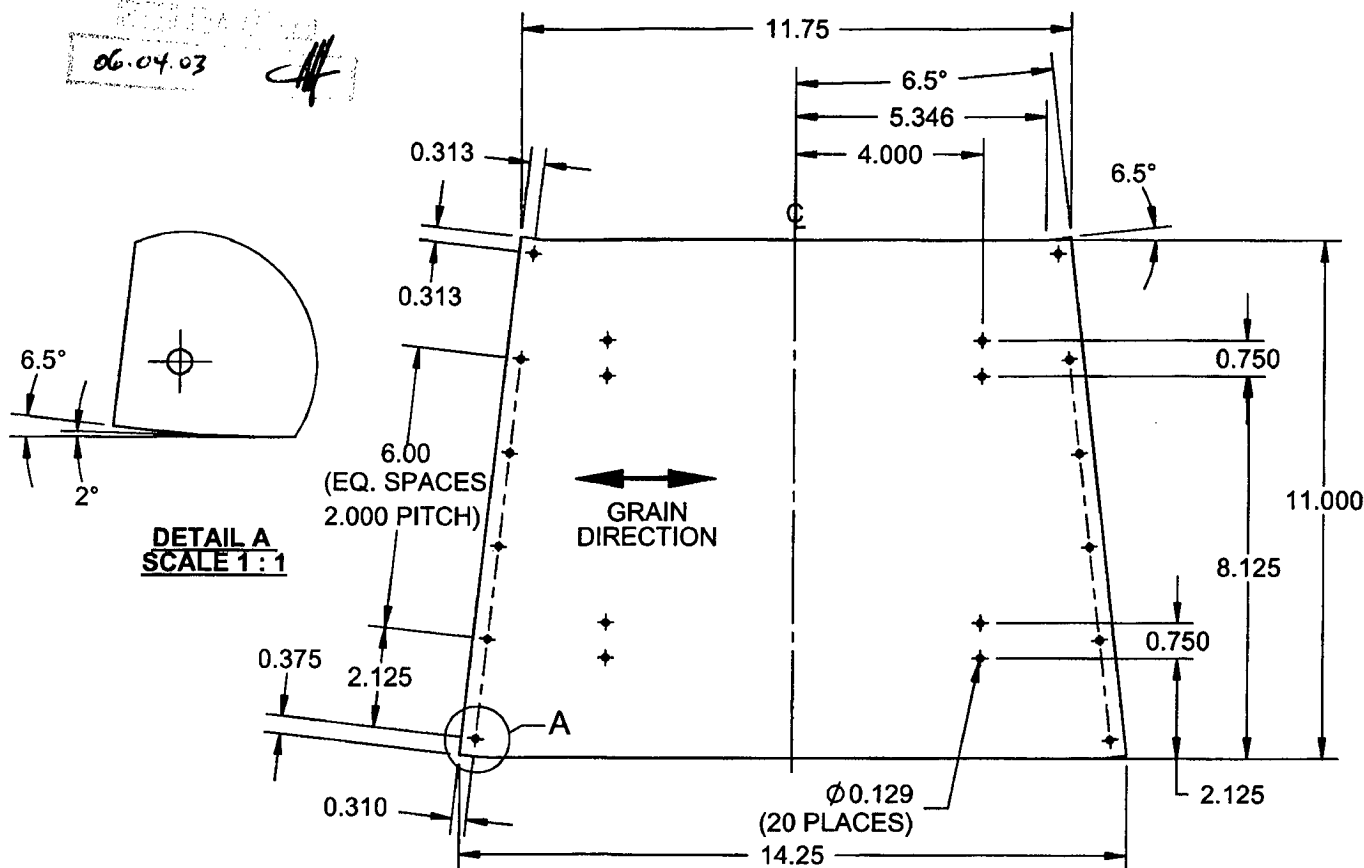
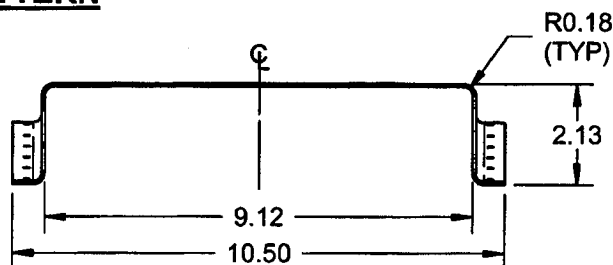
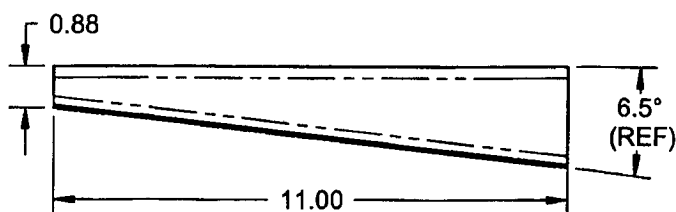
QTY -043	P/N	DESCRIPTION
X	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-3	SUPPORT
3	MS20427M-4	RIVET
1	MS35842-16	CLAMP

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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:4

**D3471-1F BASE FLAT PATTERN****D3471-1 BASE BENDING DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

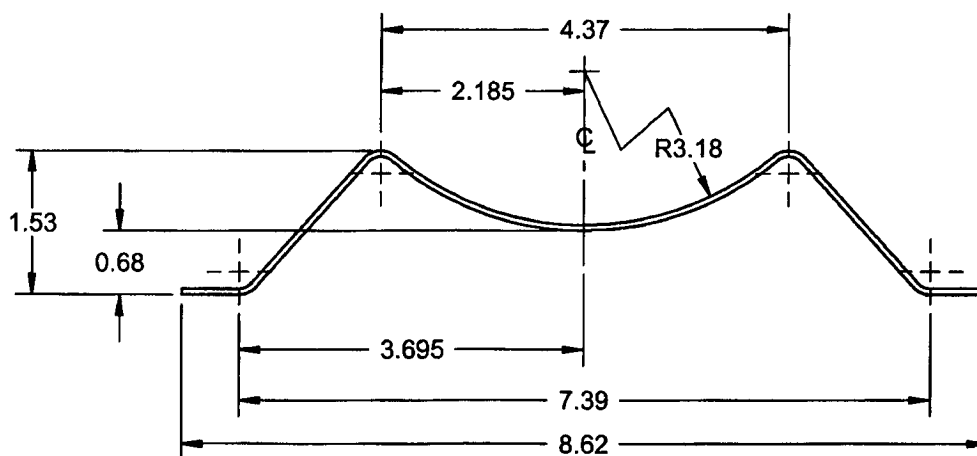
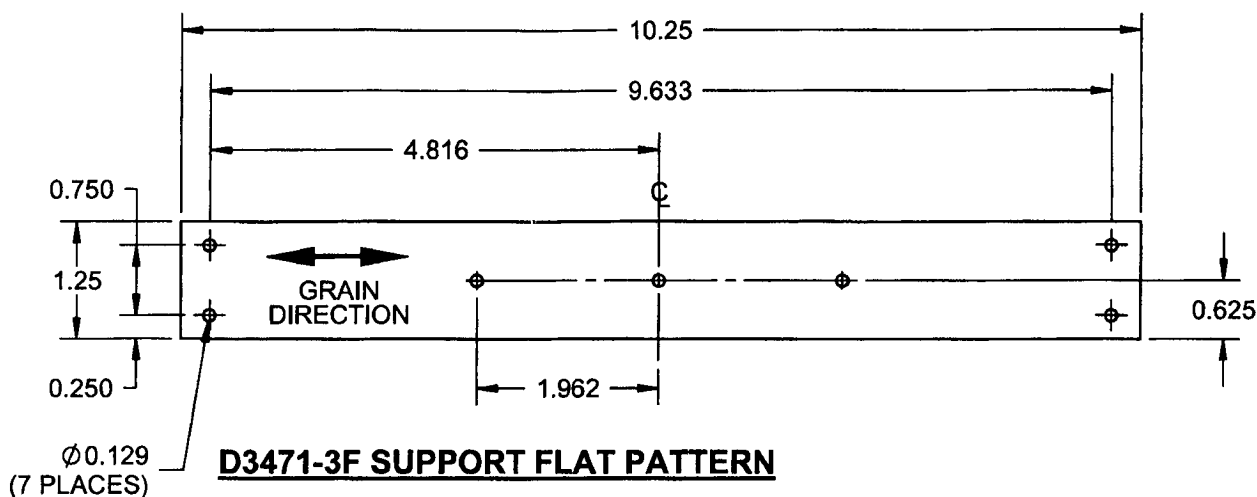
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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SHEET 4 OF 5 SCALE 1:2

06-04-03 *[Signature]***NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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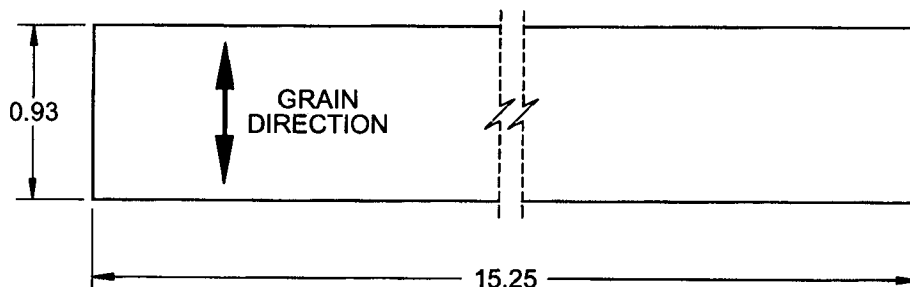
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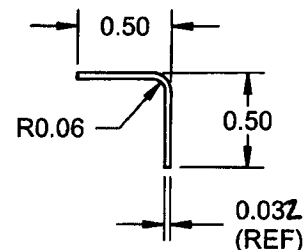


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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:1

06.04.03 *[Signature]*



D3471-5F STIFFENER FLAT PATTERN



**D3471-5 STIFFENER
BENDING DETAIL**

D3471-5 STIFFENER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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